

Date: Thursday, 07/05/2009 8:27:10 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR PANEL
Job Number : 47775	
Estimate Number : 11401	
P.O. Number :	Part Number : D32961
This Issue : 07/05/2009 S.O. No. :	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 47694	Material :
Written By :	Due Date : 14/05/2009 Qty: 15 Um: Each
Checked & Approved By : <u>JLD 09.05.07</u>	
Comment : Est C 05.10.14 Added step 14 KJ/EC Est Rev:D Now on Waterjet 06-11-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.6926 sf(s)/Unit Total : 10.3887 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)
 Identify for D3296-1
 Batch: 110980 RB 9-5-8

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3296
 Dwg Rev: A
 Prog Rev: A

RB 9-5-8

(16)

2-Deburr if necessary

RB 9-5-8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RB 9-5-8**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK50265108 (16)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

u/h S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 8:27:10 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR PANEL

Job Number: 47775

Part Number: D32961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(D40) →

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

cmd/BR

09/05/13 (X15)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-13 (X15)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 186

A 09-05-14

(15)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



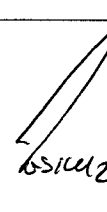


MMF 09-05-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3296-1 PAR #: N/A Fault Category: Prod/fab Assy mod & small NCR: Yes No DQA: D Date: 07/05/15
D3296-041 - D350-527-15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 07/05/15

NCR: 47775		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/13	#20	Qty 40 Found with a 1/2" cut from water jet and missing 2 holes.		Scrap and destroy qty 1 no Replne extra made -		S 07/05/13		S 07/05/13
	Found @ 60	EC machine malfunction						

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47775
Description: Door Panel		Part Number: D3296-1
Inspection Dwg: D3296 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.08	+/-0.030	5.088	X			
R0.06	+/-0.030	.06	X			
0.300	+/-0.010	.300	X			
Ø0.128	+0.005/-0.000	.131	X			
16.400	+/-0.005	16.400	X			
0.300	+/-0.010	.300	X			
13.400	+/-0.005	13.400	X			
17.00	+/-0.030	17.00	X			
14.18	+/-0.030	14.18	X			
0.300	+/-0.010	.300	X			
0.063	+/-0.010	.063	X			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-8	Date: 09/05/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue P/O D3296-041	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

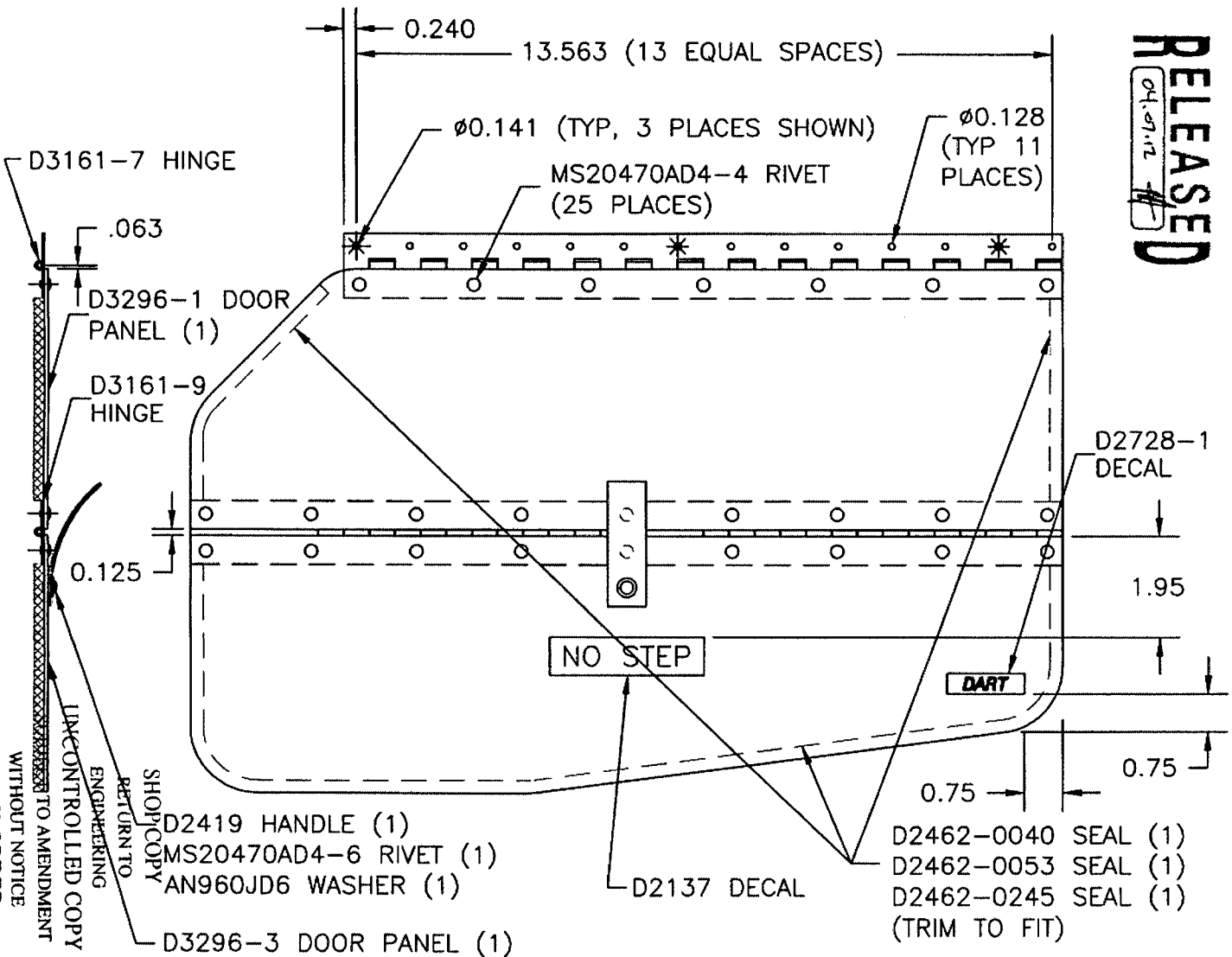
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY	DART AEROSPACE LTD	
CHECKED		APPROVED	DRAWING NO.	REV. A
DATE			D3296	1 OF 2
04.06.28			DOOR ASSEMBLY	SCALE
A		04.06.28	NEW ISSUE	1:3

RELEASED
04.07.12**D3296-041 DOOR ASSEMBLY**

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

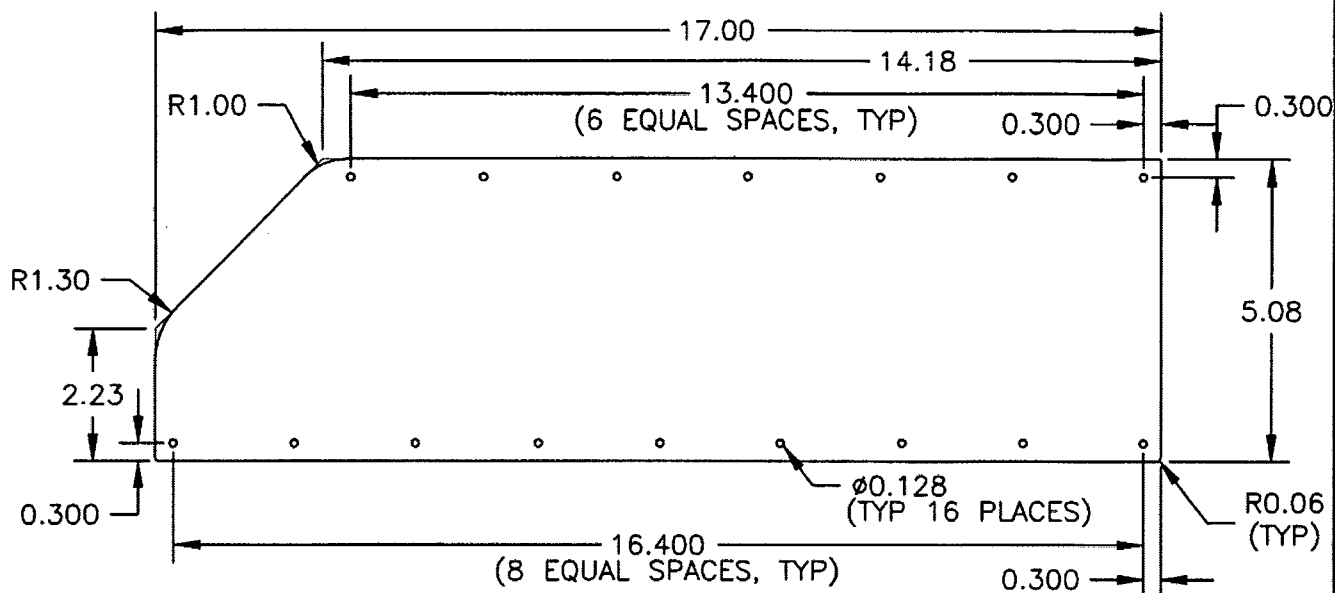
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

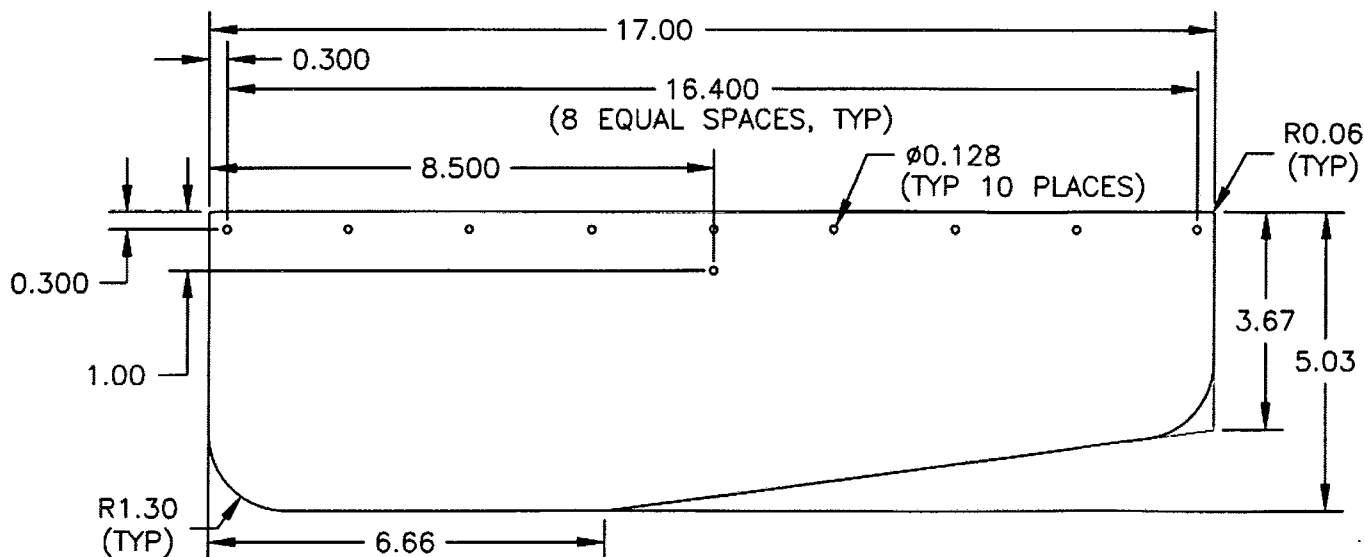
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04-07-12
ENGINEER

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47725

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